

303 R.625

Work Order ID 92973

November-12-12 3:31:32 PM

92973

Page 1

Item ID: 647.9111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Thrusert

Start Date: 12/11/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-11-13 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

647.8900

9100

Rev

N/C

12/11/14

0.00

100

100

Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA & DWG ,FOLIO REV: N/ADWG REV: N/C

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12/12/15

120

0

12/12/15

120

0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 92973

November-12-12 3:31:32 PM

92973

Page 2

Item ID: 647.9111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Thrusert

Start Date: 12/11/2012 Start Qty: 120.00

120

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

2. 2-15 120 d

Stamp
04
9-89

130

Identify as per dwg & Stock Location **ST440** 0.00

130

Packaging

Memo

0.00

Packaging

IDENTIFY WITH PERMANENT INK MARKER

120x

SP
12-12-17

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/12/18 d

ML5 12-12-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

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Page 1

Work Order ID: 92973

92973

Parent Item: 647.9111

647 9111

Parent Item Name: Thrusert

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP REV:A NEW ISSUE 12-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased		No			f	217.7982		6.315789			
M303R0 625													
303 Round Bar 0.625"													

**

7.500'

12/12/12

Location

Loc Qty

Loc Code

MAT028

217.79821

118400

2

119009

59.79821

119766

156

7.500'

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTIC. NO. 03294				SHEET 1 OF 1	
	DWG NO. 647.9100	REV: N/C	PREPARED BY A. QUAN	DATE: 12/07/11	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: THRUSERTS					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFFECT: CURRENT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED MATERIAL DUE TO AVAILABILITY ISSUES				

SHEET 1, NOTES IS:

NOTES

1. MATERIAL 303 SS IAW AMS 5640.
2. FINISH NONE
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12 PT. CENTURY GOTHIC.

SH -
P. -
E. -
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

W. -
V. -
ORDER

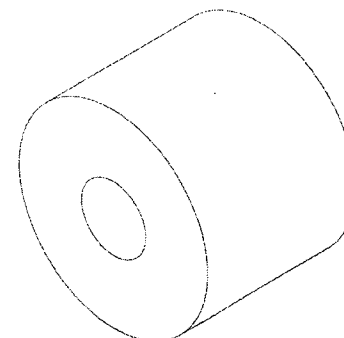
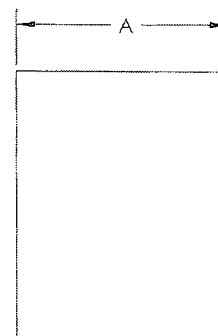
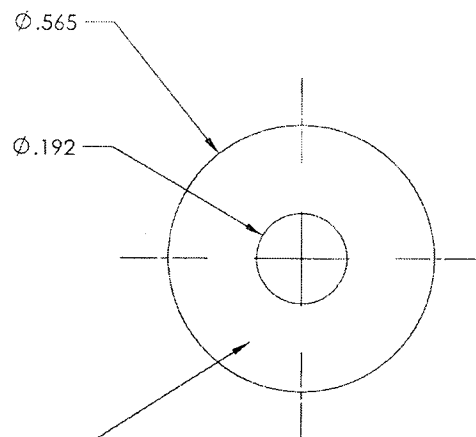
NO. 92973 MLD
12-11-13

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM						
CHANGE CATEGORY				DER REVIEW REQUIRED		
<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR				<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO		

NOTES:

1. MATERIAL: 303 SS IAW AMS 5643, 1/4H.
2. FINISH: NONE.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12 PT. CENTURY GOTHIC.

92973



647.911X

UNINCORPORATED ECN(S)

032014

P/N	LENGTH (A)
647.9110	.450
647.9111	.535
647.9112	.140
647.9113	.300
647.9114	.545

QTY		PARTS LIST	
NEXT ASSY IS		CIRCULAR DATE 647.8900 DRAWING BY: [] CHECKED BY: [] DESIGNED BY: [] DRAWING APPROVAL: [] CONTRACT NO.: []	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE .001 2 PLACE DECIMALS = .01 3 PLACE DECIMALS = .001 ANGLES = °		APICAL INDUSTRIES 2606 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 THRUSERT	
SIZE	CAGE CODE	DWG NO.	REV.
B	02/MAL6	647.9100	N/C
SCALE NONE		SHEET 1 OF 1	

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15